

Date: Tuesday, 1/15/2008 3:05:24 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 X-TUBE LOW NARROW AFT
 Job Number : 36646
 Estimate Number : 13019
 P.O. Number :
 This Issue : 1/15/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D212664207
 First Issue : 1/7/2008 Type : LANDING GEAR Drawing Number : D212-664-247-~~UR~~ A
 Previous Run : 36645 Drawing Revision : ~~UR~~ A
 Material :
 Due Date : 2/5/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08.01.15
 Comment : Est Rev: A New Issue 07.09.12 EC verified by: JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

2.0 D6008132 Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6008-132 Crosstube 32920

Check OD = 3.250"; ID = 2.375"

RD 08/01/22

①

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: 1-TURN AS PER FOLIO E 706 & DWG D212-664-247,

FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

RD 08/01/23

①

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/01/23

①

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/01/28

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 3:05:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36646

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 8-1-30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JD 8-1-30 (41)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 8-1-30

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

(P2)

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12.0

D36601

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch:

Scrap

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1


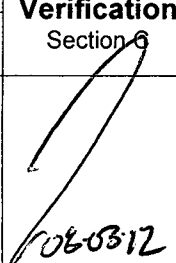
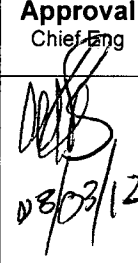
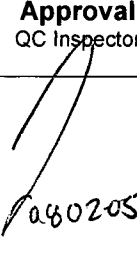
1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-247

3-Ream hole to finish size in tube as per Dwg D212-664-247

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-207 PAR #: N/A Fault Category: Prod / Landing Gear NCR: (Yes) No DQA: 2 Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR: 08-024		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-02-05	9.0	After bending the tube, it was noticed that there were longitudinal marking on the inside walls.	 08/03/12	- See NCR.08-024 See NCR.08-024 - use Dr test bends on the new bender.	JD 8-3-12	 08/03/12	 08/03/12	 080205

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE LOW NARROW AFT

Job Number: 36646

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

20.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247, with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36646

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
CHERRY RIVET
Batch: _____

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Support
batch: _____

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.8295 sf(s)/Unit Total : 0.8295 sf(s)
Rubber Cushion
Cut to .630" X 5.3" Qty 4
Batch: _____

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Clamp
Batch: _____

27.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36646

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch _____

29.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut
batch _____

30.0

AN960JD616

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer
batch _____

31.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
batch _____

32.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
Assemble as per Dwg D212-664-247

Instal support with magnobond 6398 per dwg D212-664-247,
cure for 12hrs before packaging.

Time & date of application: _____

Batch: _____

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW NARROW AFT

Job Number: 36646

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-207

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/3/12



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36646
Description: Crosstube Assembly (205/212 Low Aft)	Part Number:	D212-664-247
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

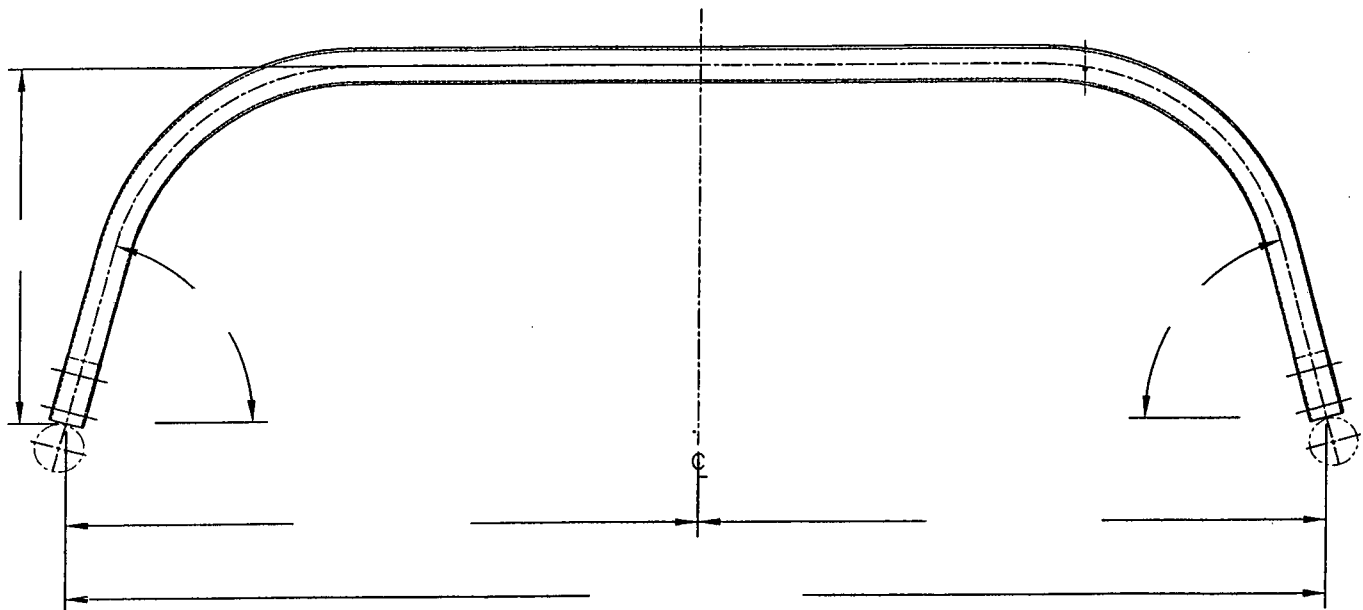
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A							
SIDE B							

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue (P/O D212-664-207)	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	36646
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A		New Issue		

PARTS LIST:

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

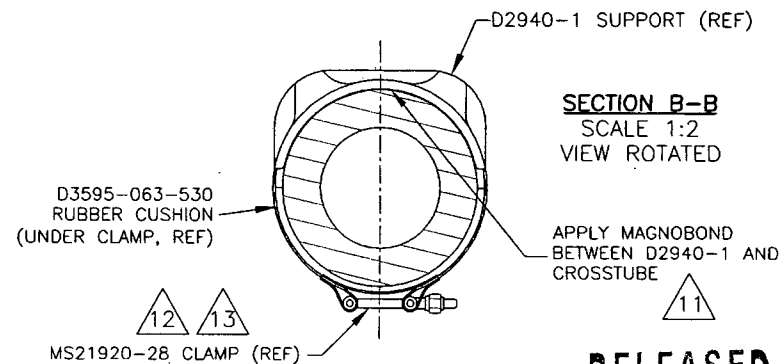
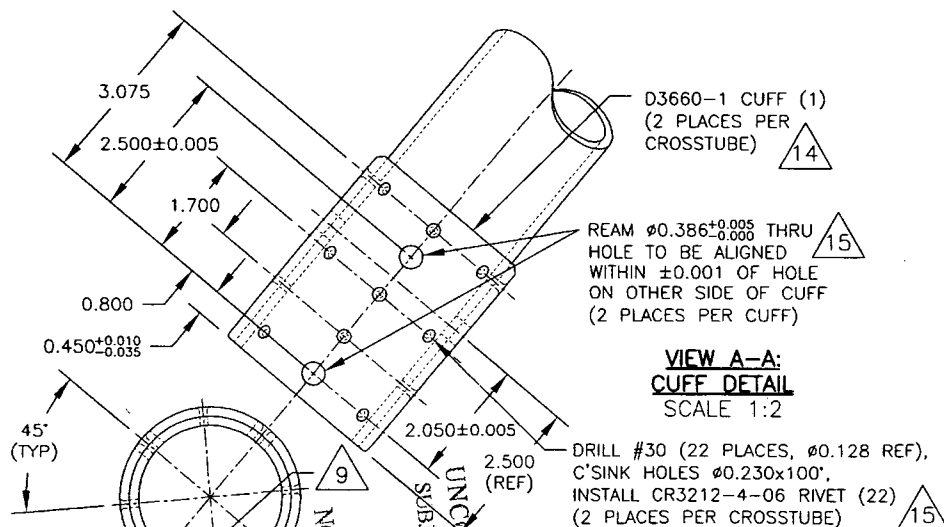
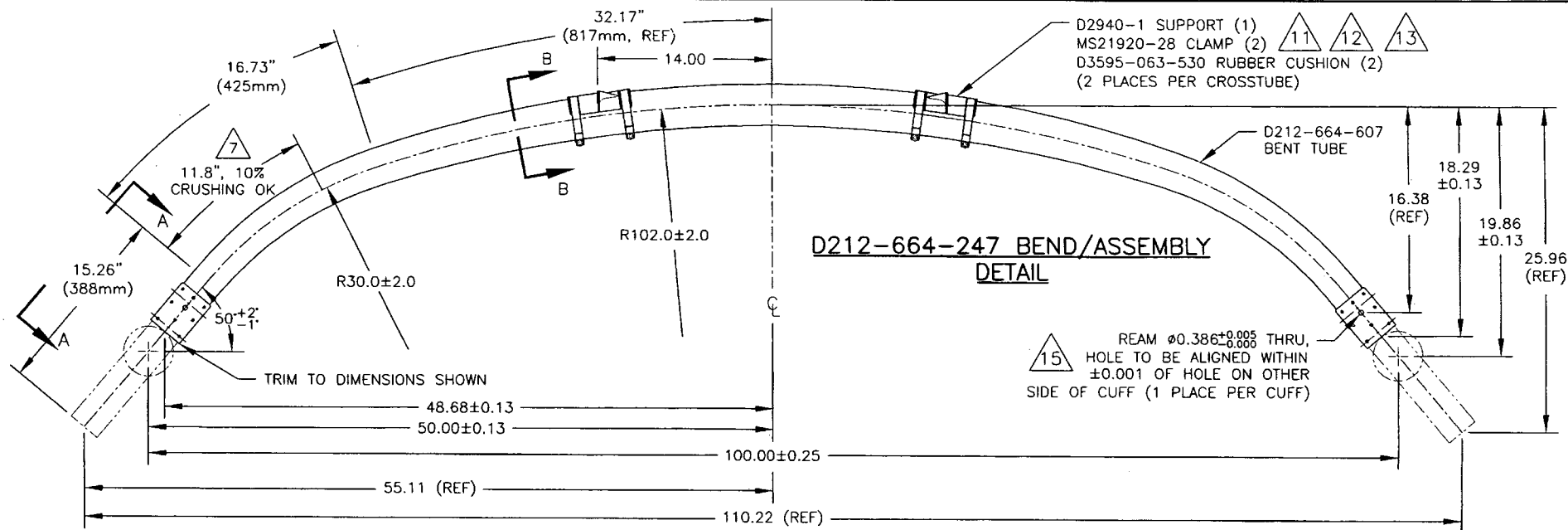
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.27 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

RELEASED
07.09.24 #

NO. 36646
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

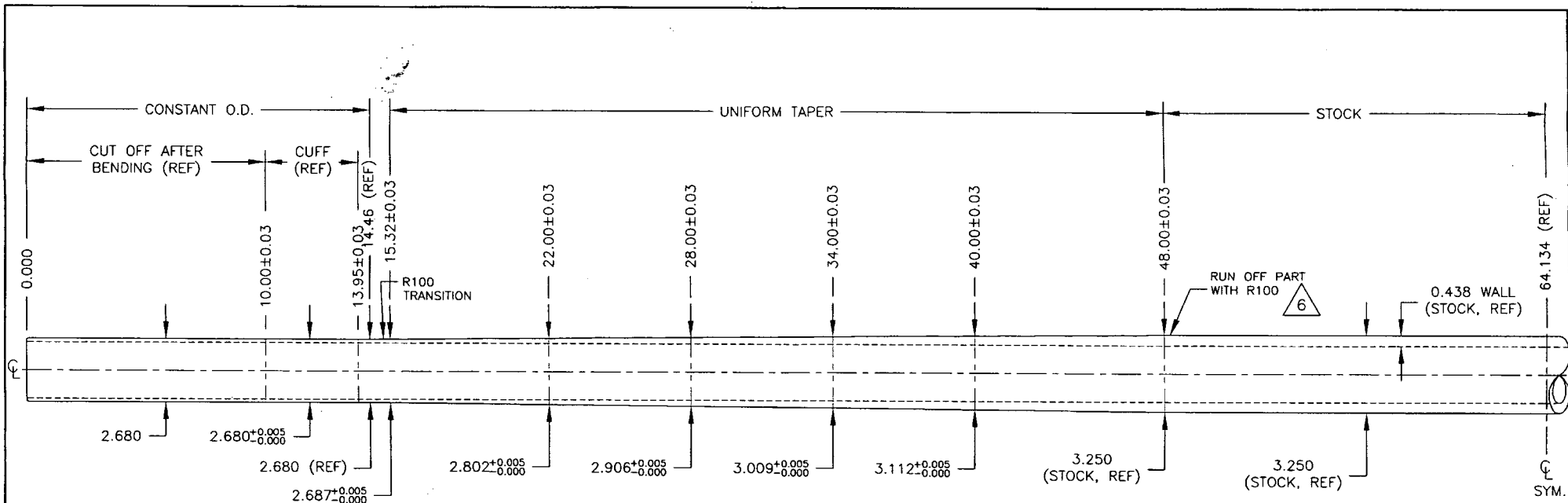
A		07.07.07	NEW ISSUE	
DESIGN	AP	DRAWN BY	AP	DART DART AEROSPACE LTD. <small>HAWKESBURY, ONTARIO, CANADA</small>
CHECKED	PH	APPROVED	PH	
DATE		07.07.07		
TITLE		CROSSTUBE (205/212 LOW AFT)		
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DRAWING NO.		D212-664-247		REV. A
SHEET 1 OF 3		SCALE		NTS



RELEASED
67.07.24

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DATE 07.07.07		TITLE CROSSTUBE (205/212 LOW AFT)		SCALE 1:8	

NO. 30046
WORK ORDER
30046
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ENGINEERING
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D212-664-247 MACHINING DETAIL

RELEASED
07.04.24

128.268
128.270

NO. 366246
WORK ORDER
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DATE		07.07.07		DRAWING NO.	REV. A
				D212-664-247	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (205/212 LOW AFT)	1:4

DART AEROSPACE LTD		Work Order:	36644
Description: Crosstube Assembly (205/212 Low Aft)		Part Number:	D212-664-247
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.686	+/- .010	2.683				
	2.680	+ .005 - .00	2.685				
	2.687	+ .005 - 0.0	2.692				
	2.802	+ .005 - 0.0	2.807				
	2.906	+ .005 - 0.0	2.909				
	3.009	+ .005 - 0.0	3.014				
	3.112	+ .005 - 0.0	3.117				
SIDE B	128.27	+/- .020	128.25				
	2.680	+/- .010	2.685				
	2.680	+ .005	2.685				
	2.687	+ .005	2.692				
	2.802	+ .005	2.807				
	2.906	+ .005	2.910				
	3.009	+ .005	3.014				
	3.112	+ .005	3.1165				

Measured by:	RP	Audited by:	JF	Prototype Approval:	N/A
Date:	08/01/23	Date:	08/01/28	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A		New Issue (P/O D212-664-207)	KJ/EC/DD		

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: February 5, 2008 3:07 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'
Subject: RE: NCR D6008 EXTRUSION (3.25 OD x 2.375 ID)

Hi Chris

As discussed, I recommend that we stop production on that 1 tube and ask for a refund. I am not comfortable with the finish on the inside of that one tube and I am concerned that it could lead to a stress riser.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, February 05, 2008 10:12 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Murdoch, Jason'
Subject: NCR D6008 EXTRUSION (3.25 OD x 2.375 ID)

David,

They are about to bend a tube that uses the D6008 extrusion (3.25 OD x 2.375 ID). There are longitudinal marks through the entire length of the tube, although it is far more pronounced on the side shown in the attached pictures. Nobody has seen this before. There's a variety of pics attached with different lighting conditions.

It doesn't appear to be marks (scratches, grooves) rather some sort of aluminum scale on the surface of the tube (ie. raised about the surface of the material). However I can't vouch for the entire length of the tube, I'm only looking at what's at the cuff. As I'm writing this, I'm thinking maybe we could buff the ID at one cuff to see what's raised and what's a scratch, as the raised bits should come off easier...

I've checked a few other D6008 from the same b/n (raw extrusion) and don't see this marking.

Because they're longitudinal, and on the inside of the tube, I think we can accept this tube. However, its rather unusual.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.516 / Virus Database: 269.19.20/1260 - Release Date: 2/5/2008 9:44 AM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.516 / Virus Database: 269.19.20/1260 - Release Date: 2/5/2008 9:44 AM

2008-02-06